Work Order ID 12	526	1
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125261

Page 1

Tuesday, Octobe	r 07, 2014 10	0:39:26 Al	M			. 3/()							
Revision ID:	D3391-023				Accept	*N90	0040	100)* ፡	Setup Sta	I VI	S1*	
Item Name:	Mid Tube Asse	embly								311	_ь хИ	S2*	
Start Date:	9/25/14	Start Qt	y: 1.00	*1*	t	Cust Ite	em ID:						
Required Date: Reference:	10/06/14	Req'd Q	ty: 1.00	*1*	t	Custom	er: 🗢					,	
Approvals:	Process Plan	n: <u>M</u>	5	Date: 14-10	08 Tooling:		Datë: 🕶		F	Run Sta	~1 <i>\</i> 1	R1*	
	QC:		p-w	Date:	SPC (Y/N):		Date:	<u> </u>		Sto	, *V	R2*	
Sequence ID/ Work Center ID)	Operatio Descripti			Set Up/ Run Hours	Tool I	D Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revi	sion Nbr											
D3391	I												
100			·		0.00								
100		Skidtubes											
Skidtubes			Memo		0.00								
Skidtubes			1-Cut tube	e to finish length as per	Dwg D3391								
			-	ot holes using DT8796 e on one side only as p	(Do not drill "B" holes) and er Dwg D3391	d drill only 1 fwd							
			3-Opèn sa	ddles and GHW holes t	o Ø0.4375" exept for fwd s	addle hole of detail	1	$\langle l \rangle$	14	-{Q -	-9		
			4-Remove	.030" from Fwd index	ing Ridge as per Dwg D339	91	/ 1	ال					
			5-Remove	indexing ridge on Fwo	& Aft end of skidtube as p	per Dwg D3391							
			6-Deburr										
			7- Locate	D3391-021 in D3391-0	023 at 9.00" (see view z-z)								
			remaining dia hole, u tranfer dri ON FIRST per ON 2ND	s fwd saddle holes using t-pins and clicos telled pilot holes in D339 I SIDE ONLY drill out	hole only to .188" dia, trans p DT 8149 locating from pro o ensure perfect allingment 01-023/-021 using drill pres 2nd and forth fwd saddles 2nd and forth saddle hole to	eviusly drill .188" s, open up previusly ss. holes to 0.500" as)u(.	-11-1	2		

DQA:		. Date:											**	
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UI		roW	k Order up	date only	\neg	AEROSPACE
Work Orde	r:				DISPOSITION				AGAINST [DEP	ARTMENT/	PROCESS	-	
Part No	0.			_	Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root				Desci	ription of work order update	П	Initial	Act	\neg					
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription		Sign & Date	Verification	,	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved					·									
						FAI	ULT CAT	regory						•
Landin					General		1		r			_		
- - - - - -	Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea	nk/Ripple	e/Wave		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing		Grain Hardwa Inspecti Instruct Misalig	Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge					Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other	
	Marks/Ch	atter			Drill Holes		Off-set			_				
	Turning S Wave/Tw				Finish Fit/Function		4	Calibration Sequence	•	_				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Order I	D 125261
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125261

Page 2

	er 07, 2014 1	.U.JJ.27 AM										
Item ID: Revision ID:	D3391-023			Accept	*N900	040	100)*	Setup	Start	*N:	S1*
Item Name:	Mid Tube As	sembly								Stop	*N:	S2*
Start Date:	9/25/14	Start Qty: 1.00	*1*		Cust Item]	ID:						
Required Dates	: 10/06/14	Req'd Qty: 1.00	*1*		Customer:							
Reference:												
Approvals:	Process Pla	an:	Date:	Tooling:	D	ate:]	Run	Start	*N	R1*
	QC:		_ Date:	_ SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center I	D	paint marke ***DO NO' Open wearp (10 holes) a Open wearp (20 holes) a ***DO NO' Deburr and aft end. 10- Locatin wearplte ho	pilot holes using wearplater, T DRILL HOLES #3-19-20 plate holes of D3391-023 a s per Dwg D3391 plate holes of D3391-023 a s per Dwg D3391 T OPEN 2 MOST FWD W blow out all chips from ins g from two fwd wearplate les in D3391-021 using D 0 wearplate holes in D3391	D FROM FWD END OF J ssembly detail section G-C ssembly detail section H-H EARPLATE HOLES*** side tube, scribe batch # in tholes in D3391-023 drill r	GG to Ø0.250" I to Ø0.297" D3391-023 at	Tool #	Plan Code	Accept Qty	Rej Qty	,]	Reject Number	Insp. Stamp
				_		1 .1						

DQA:		_ Date:			·	DART						
QA Closed:	٠	Date:			WORK ORDER NON-	-C(ONFO	RMANCE / U		ork Order up	ndate only	AEROSPACE
					DISPOSITION					PARTMENT		
Work Orde	er:					,	i	p	AGAII(S) DI	-		
	`				Rework		İ	Skid-tube	Crosstube	_	Water Jet	Engineering
Part N	10				Scrap			Machining	Small Fab		d. Eng. Coor.	Quality
					Use-as-is		Thern	noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR N	No		• •		Suspected Unapproved			Large Fab	Composite		Supplier	
Root				Desci	ription of work order update		Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Design												
Doc/Data		ĺ										
Equip/Tooling												
Handling/Pre					!							
Material										•		
Operator					ł	ĺ						,
Offset/Setup												
Process												
Supplier												
Training -				,	i							
Transport						۱.						
Unapproved	<u>"</u>	<u> </u>	<u> </u>	<u> </u>		F 0 1		TECORY				
Landie	ng Gear				General	FAI	JLI CA	regory				
Latiuii	Bending				Bend	г	leolio/c	rogram		Outside Dim	onsions	Pressure/Forced
	Centre N	ot Conce	ntric		BOM/Route	\vdash	Grain	Togram	\vdash	Over/Under	 	Set-up
	Cracks	,	Terre		Broken/Damage/Defect	┢	Hardwa	ire	<u> </u> -	Part Incorred	-	Temperature/Cure
	Crimp/Ki	nk/Ripple	/Wave		Burrs	\vdash	1	ion Incomplete/U	ngualified	Part Lost/Mi	. —	Weld
	Cuffs	my mppic	,, wave		Contamination	┢	1 '	tions Incomplete/	<u> </u>	Part Moved		Wrong Stock Pulled
	Crushing				Countersink	\vdash	1	ned/off center	-	Positioned V		
	Heat Trea				Cut Too Short	Mislabeled Power Loss/Surge				· .	Other	
ľ	Inspectio	n Strip in	Tube		Drawing		Misread			.	· _	<u>.</u>
ľ	Marks/Cl	٠,			Drill Holes	Г	Off-set					
	Turning S	Sequence			Finish	Г	┪					
	Wave/Tw	vist in Tub	oe		Fit/Function		Out of Calibration Out of Sequence					

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Order ID 125261

125261

Page 3

Tuesday, October 07, 2014 10:39:27 AM D3391-023 Item ID: Accept *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Mid Tube Assembly *1* **Start Date:** 9/25/14 Start Qty: 1.00 **Cust Item ID:** Required Date: 10/06/14 Req'd Qty: 1.00 *1* **Customer:** Reference: Run Start Date: **Tooling:** Date: **Approvals:** Process Plan: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Description Code Qty Number Stamp **Work Center ID** Oty **Run Hours** 120 Chemical Conversion Coat per QSI005 4.1 0.00 1 6 14-11-17 DGC *120* HandFinish 0.00 Memo Hand Finishing QC7-Inspect Chemical Conversion Coat 0.00 130 *130* 0.00 Memo Quality Control .

DQA:			Date:										**	A DT		
						WORK ORDER NON	ORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:						^	,	Work Order u	odate only				
Work Orde	er:					DISPOSITION				AGAINST I	DEPARTMENT	/PROCESS	-			
Part N	- - ۱٥٠	****				Rework Scrap Use-as-is			Skid-tube Machining	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging		Engineering Quality Other		
NCR N	۱o			·*·.		Suspected Unapproved]	mem	Large Fab	Composite		Supplier		, Other		
Root					Desc	ription of work order update		nitial	Ac	tion	Sign &		\Box			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	n	QC Inspector		
Design Doc/Data			•													
Equip/Tooling	_								'							
Handling/Pre											1					
Material -	_															
Operator										-						
Offset/Setup																
Process	_															
Supplier Training	\dashv															
Transport	_															
Unapproved	_								· .							
				L			FAI	JLT CAT	EGORY		<u> I ,</u>	<u> </u>				
Landir	ng G	ear				General		,		*	.= •					
ſ		Bending				Bend		Folio/P	rogram	Γ	Outside Dim	ensions		Pressure/Forced		
		Centre No	t Concer	ntric		BOM/Route		Grain		Ī	Over/Under	tolerance	-	Set-up		
	(Cracks				Broken/Damage/Defect		Hardwa	re	Ī	Part Incorre	ct	\vdash	Temperature/Cure		
	(Crimp/Kir	k/Ripple,	/Wave		Burrs		Inspecti	on Incomplete/U	ngualified	Part Lost/M	ssing	\prod_{i}	Weld		
	(Cuffs				Contamination		Instruct	ions Incomplete/	Unclear	Part Moved		\Box ,	Wrong Stock Pulled		
		Crushing				Countersink		1	ned/off center	Ţ	Positioned V	ر Vrong		•		
	i	Heat Trea	t			Cut Too Short		Mislabe		Ī	Power Loss/	Surge	\Box	Other		
]	nspection	n Strip in	Tube		Drawing		Misread	I			,				
,	اا	Marks/Ch	atter			Drill Holes		Off-set								
		Turning S	equence			Finish		Out of 0	Calibration	•						
[Π,	Wave/Tw	ist in Tub	e		Fit/Function	\Box	Out of s	Sequence							

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work	Order ID	12526
Tuesday,	October 07, 2	2014 10:39:

125261

Page 4

Tuesday, Octob	er 07, 2014	10:39:27 AM		" 1 / 5)/n "							1 45	
Item ID: Revision ID:	D3391-023			Accept	*N900	<u>040</u>	100)*	Setup	Start	*N	S1*	
Item Name:	Mid Tube As	ssembly								Stop	*N	S2*	
Start Date:	9/25/14	Start Qty: 1.00	*1*		Cust Item	ID:							
Required Date	: 10/06/14	Req'd Qty: 1.00	*1*		Customer:		•						
Reference:			•							-			
Approvals:	Process Pl	an:	Date:	Tooling:	D	ate:	_		Run	Start	*N	R1*	•
	QC:		Date:	_ SPC (Y/N):	D	ate:				Stop	*N	R2*	•
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Re		Reject Number	Insp. Stamp	
140				0.00									
140		Skidtubes											_
Skidtubes		Memo		0.00		\							
Skidtubes		2-C ['] sink flor 3- Prepare to 4-Bond web Adhere for 1	x exp: <u>15~8~19</u>	91 & QSI 015.		W		11-18					
		NOTE:ENS	URE WEB IS INSERTED	IN AFT END OF TUBE									DAS 18
150		QC5- Inspect part compl	leteness to step on W/O	0.00)			9-30
150		Memo		0.00						8	14-1	1-19	_
Quality Control		MEHIO											

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE							W	DART
QA Closed:			Date:			WORK ORDER NOW		JIVIOI	MINIAINCE / O		ork Order up	date only		AEROSPACE
Work Orde	er:			-	·	DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
Part N NCR N	10.					Rework Scrap Use-as-is Suspected Unapproved		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root					Desci	ription of work order update		Initial	Act	tion	Sign &		1	
Cause		Date	Step	Qty		or non-conformance		nief Eng	Desc	ription	Date	Verification	ı	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	<i>d</i>									·				
01 ~***							FA	ULT CAT	EGORY					
Landir	ng C	ear			,	General								
		Bending Centre No Cracks Crimp/Kin Cuffs				Bend BOM/Route Broken/Damage/Defect Burrs Contamination		Grain Hardwa Inspecti Instruct	on Incomplete/Ui	· · · · · · · · · · · · · · · · · · ·	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved	tolerance et ssing		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled
		Crushing Heat Trea Inspection Marks/Ch	n Strip in	Tube		Countersink Cut Too Short Drawing		Mislabe Misread			Positioned W Power Loss/S		(Other
		Turning So Wave/Tw	equence			Drill Holes Finish Fit/Function		1	Calibration Sequence					

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

									10.00		
Work Ord Tuesday, Octob				*125	5261*						Page 5
Item ID: Revision ID: Item Name:	D3391-023 Mid Tube Ass	sembly		Accept	*N900	1 040	100)* 5	Setup Sta	•	NS1*
Start Date: Required Date Reference:	9/25/14 :: 10/06/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer						14.12
Approvals:	Process Pla	ın:	Date:	Tooling:		Date:	-	F			NR1*
	QC:		Date:	_ SPC (Y/N):		Date:	_		Ste	op 🛪	NR2*
Sequence ID/ Work Center I	(D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reje Nun	nber Stamp
*160 *160*		Skidtubes		0.00					0	/4	4119 BE
Skidtubes Skidtubes		Memo 1-Weld cros 2-grind weld	sbolt spacer as per dwg D3 I flush	0.00 3391 & QSI 004 A- K	' m1a9a 85						
170 +4 70 +		QC10- Inspect visual per	QSI004- ground welds	0.00				ľ			DAS 38
170 QC Quality Control		Memo		0.00	•						

180

QC5- Inspect part completeness to step on W/O

0.00

1 20

Quality Control

Memo

0.00

Quality Control

DA6 38 9-89 14-11-20

DQA:			Date:			WORK ODDED NON	DER NON-CONFORMANCE / UPDATE						
QA Closed:			Date:			WORK ORDER NON-	-00	JINFOI	AIVIAIVE / C		ork Order up	date only	AEROSPACE
Work Orde	or.					DISPOSITION				AGAINST DI	EPARTMENT,	PROCESS	
WOIR OTHE	_					Rework	1 1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	_					Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	No		,			Suspected Unapproved			Large Fab	Composite		Supplier	
Root		******			Desci	ription of work order update		Initial	А	ction	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Des	cription	Date	Verification	QC Inspector
Design	Ш		:										
Doc/Data													
Equip/Tooling													
Handling/Pre	Щ												
Material	\Box	•											
Operator	\square												
Offset/Setup	\square								İ				
Process	Щ						1						
Supplier	\square											-	
Training													
Transport	Н												
Unapproved			L		<u> </u>		<u> </u>					<u>.</u>	
							FA	ULT CAT	regory				
Landi						General		1			7	. г	
	-	Bending			-	Bend	_	- 1	rogram	-	Outside Dim		Pressure/Forced
	\vdash	Centre No	ot Concer	ntric	-	BOM/Route	<u> </u>	Grain		<u> </u>	Over/Under	F	Set-up
•	\vdash	Cracks	1.45: 1		<u> </u>	Broken/Damage/Defect	\vdash	Hardwa			Part Incorred	F	Temperature/Cure
!	—-	Crimp/Kir	ik/Ripple	/Wave	-	Burrs	ļ	-	ion Incomplete/		Part Lost/Mi		Weld
,	\vdash	Cuffs			<u> </u>	Contamination		4	ions Incomplete	├	Part Moved		Wrong Stock Pulled
	Н.	Crushing				Countersink	\vdash	-1	ned/off center	r 	Positioned V	· .	
	-	Heat Trea		T i	<u> </u>	Cut Too Short	Mislabeled Power Loss/Surge				Other		
	-	Inspection		rupe	-	Drawing	\vdash	Misread	1		 		
	\vdash	Marks/Ch		•	-	Drill Holes	-	Off-set	California i				
	-	Turning S			<u> </u>	Finish	<u> </u>	-	Calibration				
	l l	Wave/Tw	ist in Tuk	e e		Fit/Function	1	Out of S	Sequence				

Tuesday, October 07, 2014 10:39:27 AM D3391-023 Accept **Item ID:** *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Mid Tube Assembly *1* Start Qty: 1.00 **Start Date:** 9/25/14 **Cust Item ID:** Required Date: 10/06/14 **Reg'd Oty:** 1.00 *1* **Customer:** Reference: Start Run **Approvals:** Process Plan: Date: **Tooling:** Date: Stop SPC (Y/N): Date: Date: Sequence ID/ Operation Tool ID Tool # Plan Reject Insp. Set Up/ Accept Reject **Work Center ID Description Run Hours** Code **Qty Qty** Number

Stamp 185 Pressure Wash per QSI005 4.3 0.00 *125* HandFinish 0.00 Memo Hand Finishing ✓ AND REALODINE AS PER PAR09-043

190

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

0.00

190

Powdercoat

Powder Coating

FINISH TIME:

200

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

1 & M. B.1 853

DQA:			. Date:	·		WORK ORDER NON	WORK ORDER NON-CONFORMANCE / UPDATE								
QA Closed:			Date:								/ork Order up	odate only		AEROSPACE	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS			
Part N NCR N	_					Rework Scrap Use-as-is Suspected Unapproved		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite				Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other	
Root					Desc	ription of work order update	Τ	Initial	Act	tion	Sign &				
Cause		Date	Step	Qty		or non-conformance		nief Eng	Desci	ription	Date	Verificatio	n	QC Inspector	
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport: Unapproved															
				·			FA	ULT CA	TEGORY					•	
Landir ,		Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspection Marks/Ch	n Strip in	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislaba Misread Off-set	ion Incomplete/Utions Incomple	<u> </u>	Outside Dim Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	tolerance ct issing Vrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other	
			ist in Tub			Fit/Function		-∮	Sequence						

Work Ord Tuesday, Octobe							Page 7					
Item ID: Revision ID: Item Name: Start Date:	D3391-023 Mid Tube Ass 9/25/14	Start Qty: 1.00	*1*	Accept	*N9000		100) *	-	Start Stop	*N *N	S1* S2*
Required Date: Reference:	: 10/00/14	Req'd Qty: 1.00	*1*		Customer:							
Approvals:	Process Pla	ın:	Date:	Tooling:	Da	te:	_			Start	*N	R1*
	QC:		Date:	SPC (Y/N):	Da	· · · · · · · · · · · · · · · · · · ·			Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
230 HandFinish		HandFinishing Memo	oute on mon Duya	0.00				<u> </u>		· u	HO	14/12/67
Hand Finishing		1-mstan inst	erts as per Dwg									
240 +0.4.0 +		QC5- Inspect part compl	eteness to step on W/O	0.00				ì				DAS
* 240 * QC Quality Control		Memo		0.00					_	<u></u>	.	38 989 14-12-0

250

Identify as per dwg & Stock Location: w/o

0.00 D-112-742-043/13126413

250 Packaging

Memo

0.00

Packaging

DQA:			Date:										TQ AC		
						WORK ORDER NON-	·CC	ONFO	RMANCE / U				AEROSPACE		
QA Closed:			Date:							W	ork Order up	date only			
Work Orde	∍r·					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS			
Work Orac	-	· · ·	•			Rework			Skid-tube	Crosstube	7	Water Jet	Engineering		
Part N	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
	-					Use-as-is		i i	noforming	Finishing	┥	re/Packaging	Other		
NCR N	۱o. <u>-</u>					Suspected Unapproved			Large Fab	Composite	Supplier				
Root	- 1				Dosci	ription of work order update		nitial	Action		Sign &				
Cause		Date	Step	Qty	Desci	or non-conformance		iief Eng	1	ription	Date	Verification	QC Inspector		
Design	\vdash	Date	Step	Qty.		of non-comormance	Cil	ilei Liig	Desc	приоп	Date	vermeation	QC 113pcctor		
Doc/Data	\dashv														
Equip/Tooling															
Handling/Pre	\Box														
Material	П	:													
Operatór															
Offset/Setup															
Process									1						
Supplier															
Training			ĺ												
Transport						•									
Unapproved															
							FAI	ULT CA	TEGORY						
Landi	ng G	ear				General						_	_		
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced		
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up		
	-	Cracks				Broken/Damage/Defect	_	Hardwa			Part Incorred	⊢	Temperature/Cure		
* .	Crimp/Kink/Ripple/Wave			/Wave	<u> </u>	Burrs		Inspect	ion Incomplete/U	nqualified	Part Lost/Mi	ssing	Weld		
	Cuffs					Contamination		4	tions incomplete/	Unclear	Part Moved	L	Wrong Stock Pulled		
	-	Crushing				Countersink		1	gned/off center	<u> </u>	Positioned V	_	¬		
	-	Heat Trea				Cut Too Short		Mislabe		L	Power Loss/	Surge	Other		
	_	Inspection		Tube	<u> </u>	Drawing		Misread							
	-	Marks/Ch			<u> </u>	Drill Holes	_	Off-set				<u>.</u>			
!	\vdash	Turning S				Finish	<u> </u>	4	Calibration						
	Wave/Twist in Tube				ļ	Fit/Function	ł	Out of :	Sequence						

Work Ord Tuesday, Octob							Page 8					
Item ID: Revision ID: Item Name:	D3391-023			Accept	*N900	<u>040</u>	100	*	Setup	Start Stop		S1* S2*
Start Date: Required Date Reference:	9/25/14 : 10/06/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:							
Approvals:	Process P QC:	lan:	Date:	Tooling: SPC (Y/N):		ate:	-]		Start Stop		R1* R2*
Sequence ID/ Work Center I	D	Operation Description QC21- Final Inspection	- Work Order Release	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty	N	Reject Number	Insp. Stamp

0.00

Memo

Quality Control

AARU-12-04

DQA:	Date:					WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			WORK ORDER NON-	-((JNFOI	RIVIANCE / U		ork Order up	date only	AEROSPACE		
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS			
Part N						Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root					Desci	ription of work order update	1	nitial	Act	tion	Sign &				
Cause	_ D	ate	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	n QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved								·							
					·		FAI	JLT CAT	regory						
Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence					General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Ur ions Incomplete/U ned/off center eled	· —	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other			
		_	quence it in Tub	e		Finish Fit/Function	-	1	Calibration Sequence				· · · · · · · · · · · · · · · · · · ·		

Picklist Print

Tuesday, October 07, 2014 10:39:26 AM

Work Order ID: 125261

125261

Parent Item:

D3391-023

D3391-023

Parent Item Name:

Mid Tube Assembly

Start Date: 9/25/14

Required Date: 10/06/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP A05.10.20New Issue

IPP B06.02.10ECN773 dwg rev.D EC

IPP C 07.03.20 rev F dwg IPP D 07.03.28 re-format

EC EC

KJ/EC

IPP E 07.10.31 ecn 1053P

EC

IPP Rev:F ECN 1056 07-11-13 DD

verified by: EC

IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC

IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC

IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP Rev:J add in seq 140 expire date &b# sikaflex DD 10.02.17 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-1-100		Manufactured	No			100	Each	57.0000	1	1			
D2500-1-	100								**		14	1-10	-9

Location	Loc Qty	Loc Code
HALL	57	
82373	8	
86065	49	

D3389-1

Manufactured

140 Each 6.0000

1

**

Web

Location

Loc Qty 6 Loc Code

DBC 14-11-18

LG

6

DQA:			Date:												
						WORK ORDER NON-	-CC	ONFO	RMANCE / UF	PDATE			AERO	SPACE	
QA Closed:			Date:			,				W	ork Order up	date only			
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS			
WORK Orde	·' —					Rework			Skid-tube	Crosstube] .	Water Jet	Engineeri	ing	
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Qual		
,	_		·····			Use-as-is			noforming	Finishing	4	e/Packaging	Oth	` ├──	
NCR N	lo					Suspected Unapproved			Large Fab	Composite]	Supplier			
Root					Docci	ription of work order update		nitial	Action		Cian 0				
Cause		Date	Step	Qty	Desci	or non-conformance	l	iief Eng	Descri		Sign & Date	Verification	QC Insp	actor	
Design	\vdash	Date	Step	Qty		of non-comormance	C11	ilei Liig	Descri	iption	Date	verification	QC 1113p	70001	
Doc/Data															
Equip/Tooling	\dashv							*							
Handling/Pre	\dashv														
Material															
Operator															
Offset/Setup															
Process															
Supplier															
Training					:										
Transport	_		Ī						· .						
Unapproved			<u> </u>									<u> </u>			
							FAI	ULT CA	TEGORY						
Landir						General	_	,			7	_	_		
• 3		ending			<u> </u>	Bend		4	rogram?		Outside Dim	<u>-</u>	Pressure/Fo	rced	
	_		ot Concer	ntric	<u> </u>	BOM/Route	_	Grain			Over/Under	<u> </u>	Set-up		
	—≓	racks			\vdash	Broken/Damage/Defect	<u> </u>	Hardwa			Part Incorred	⊢	Temperatur	e/Cure	
}	_	• •	rk/Ripple	/Wave		Burrs		1	ion Incomplete/Un		Part Lost/Mi	ssing	Weld		
	_	uffs 			<u> </u>	Contamination	<u> </u>	4	ions Incomplete/U	Jnclear	Part Moved	_ L	Wrong Stoc	k Pulled	
	_	rushing			-	Countersink	<u> </u>	4	ned/off center	<u> </u>	Positioned V	_	¬		
		leat Trea		- .	-	Cut Too Short	<u> </u>	Mislabe		L.	Power Loss/	Surge	Other		
}	_		n Strip in	Tube	<u> </u>	Drawing	<u> </u>	Misread							
}	_	/larks/Ch			<u> </u>	Drill Holes		Off-set							
}	_	-	equence		<u> </u>	Finish		1	Calibration						
	Wave/Twist in Tube					Fit/Function	<u> </u>	Out of	Sequence						

Tuesday, October 07, 2014 10:39:26 AM

Work Order ID: 125261

125261

Parent Item:

D3391-023

Parent Item Name: Mid Tube Assembly

D3391-023

Start Date: 9/25/14

Required Date: 10/06/14

Start Qty: 1.00

**

Required Qty: 1.00

D3681-1

Manufactured

160

83.0000 Each

D3681-1

Spacer

Location	Loc Qty	Loc Code
LG	80	
(123088)	40	
(123490	40	
LG001	3	
114884	3	

ALS4-1032-130

AELS4-1032-130 Purchased

230 Each

3,693.000 20

**

20

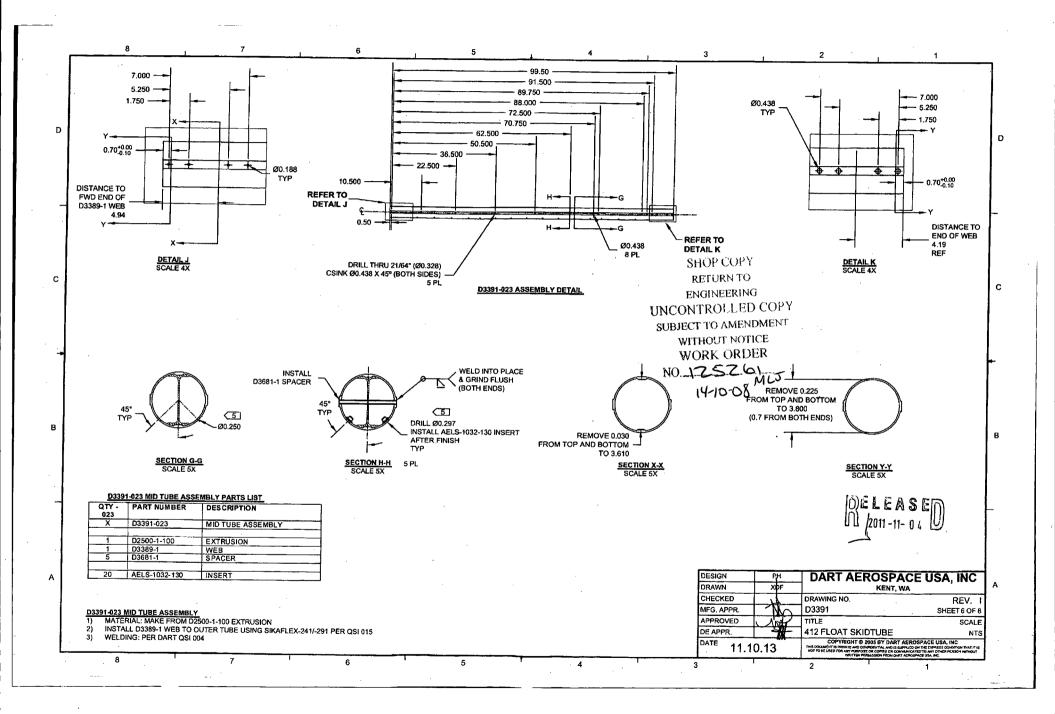
ALS4-1032-130

Rivnut

Location	Loc Oty	Loc Code
ST267	3693	
M126109	57	
M128211	48	
M128649	3588	•

X D3591-1 / B115533 (2d) Al whilez

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:			Date:			WORK ORDER NON-	-((JINFUI	RIVIAINCE / C		Vork Order up	date only	AEROSPACE			
Work Orde	or.					DISPOSITION				AGAINST D	EPARTMENT	PROCESS				
VVOIR OIG	٠٠٠ -					Rework			Skid-tube	Crosstube		Water Jet	Engineering			
Part N	۱٥.					Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality			
						Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other			
NCR N	۱٥		290			Suspected Unapproved			Large Fab	Composite		Supplier				
Root					Desci	ription of work order update	l	Initial Action			Sign &					
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector			
Design	_															
Doc/Data	-										li .					
Equip/Tooling																
Handling/Pre																
Material																
Operator	$\dot{\vdash}$															
Offset/Setup Process																
Supplier									,							
Training	\vdash			·												
Transport	\square															
Unapproved																
		L	1	1	·		FAI	ULT CAT	EGORY							
Landi	ng G	iear				General										
		Bending				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced			
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up			
		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	et [Temperature/Cure			
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/L	Inqualified	Part Lost/Mi	ssing	Weld			
:		Cuffs			ļ	Contamination		Instruct	ions Incomplete	/Unclear	Part Moved		Wrong Stock Pulled			
	Crushing			Countersink		Misalig	ned/off center		Positioned V							
	\vdash	Heat Trea				Cut Too Short		Mislabe	eled	Ĺ	Power Loss/	Surge	Other			
		Inspection		Tube		Drawing		Misread	d							
	ш	Marks/Ch			<u> </u>	Drill Holes	_	Off-set								
Turning Sequence			<u> </u>	Finish .		4	Calibration		<u> </u>	- · · · - · · · · · · · · · · · · · · ·						
Wave/Twist in Tube				Fit/Function		Out of S	Sequence									



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